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D4273-041
Job Sheet 183248



Part No: D4273-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 1,2,3,4,5 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/28/18	0.00	0.00	Start Up Large Fab-6		DC 2018-09-18
100	Large Fab	1 pcs		9/28/18	0.00	20.83	Large Fab 1		2018-09-21
110	QC	1 pcs		9/28/18	0.00	0.00	QC9		
120	QC	1 pcs		9/28/18	0.00	0.00	QC5		
125	HandFinish	1 pcs		9/28/18	0.00	0.35	HandFinish2		D.B. 18/10/09
130	Powdercoat	1 pcs		9/28/18	0.00	0.66	Powdercoat2		13K 18-10-10
140	QC	1 pcs		9/28/18	0.00	0.00	QC3		18-10-12
150	Packaging	1 pcs		9/28/18	0.00	0.00	Packaging3-2		18-10-12
160	QC21-SA	1 Ea		9/28/18	0.00	0.00	QC21		18-10-12

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION E-E ON PAGE 2 DWG D4273, NEED Descriptions: TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT10317 ***visual inspect before welding mesh*** 2- Cut D4279-1 base mesh (MADE ON THIS W/O) and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M 83983 START: 9:30. O.V.T. 375° FINISH: 9:45.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5096630
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5104485
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5105281 (1) 505281 (2)
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5110912
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5099924
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5089804
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5106776
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	5078944
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	5110971
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	5078915
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	5110979
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	5090523

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation
D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4306-043	Rib Assembly, LH	1 Ea (1 ea)	90-Start up Operation
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

3078860
 3052508
 3083614
 3083812
 3017134
 3037162
 3061190
 3089950
 3093684

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	94	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-9	1	12	0
	D3916-5	3	30	0
	D4016-1	3	10	0
	D4017-7	3	58	0
	D4021-1	3	55	0
	D4034-041	1	9	0
	D4277-19	1	2	0
	D4277-3	1	0	0
	D4277-5	2	6	0
	D4277-9	1	0	0
	D4278-045	2	4	0
	D4278-047	1	4	0
	D4279-5	1	4	0
	D4279-7	2	11	0
	D4279-9	1	10	0
	D4306-043	1	3	0
	D4306-045	1	4	0
	D4306-1	1	6	0
	D4672-1	2	24	0
	M304EX0.75-16F	32	2,192	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION F Us Suspected Unap
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

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 DART AEROSPACE Container No: S111287 Part: D4273-041 Job No: 183248 Serial No/Batch: S111287 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/10/18 1270 Aberdeen Street Newkirk, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com	val or n
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QC / QA Coordinator
Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				